

Work Order ID 108699

October-29-13 7:56:59 AM

108699

Page 1

Item ID: D3411-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Washer

Start Date: 10/29/13

Start Qty: 80.00

80

Cust Item ID:

Required Date: 10/31/13

Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3411	REV A ✓								
100		0.00							
100									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Turn as per Folio FA591 Rev: _____ & Dwg D3411 Rev: <u>A</u>								
	Deburr & Tumble as per Dwg D3411								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
44
9-89 13/11/05

81 0

DAS
44
9-89 13/11/05

81 0

DAS
40
9-89 13/11/07

81 0

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Page 2

Item ID: D3411-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Washer

Start Date: 10/29/13 Start Qty: 80.00

80

Cust Item ID:

Required Date: 10/31/13 Req'd Qty: 80.00

80

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: ~~SCOTT~~

0.00

130

Packaging

Memo

FR001

Packaging

x81 d H 13/11/07

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

JA/Rm 13/11/11

IME

13-11-09

Picklist Print

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Page 1

Work Order ID: 108699

Parent Item: D3411-3

Parent Item Name: Washer

Start Date: 10/29/13

Required Date: 10/31/13

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP A05.10.19New issueKJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR1.000 Delrin Round Bar 1"		Purchased	No			100	f	5.9300	0.0136	2			

Location

Loc Qty

Loc Code

MAT

5.93

m126794

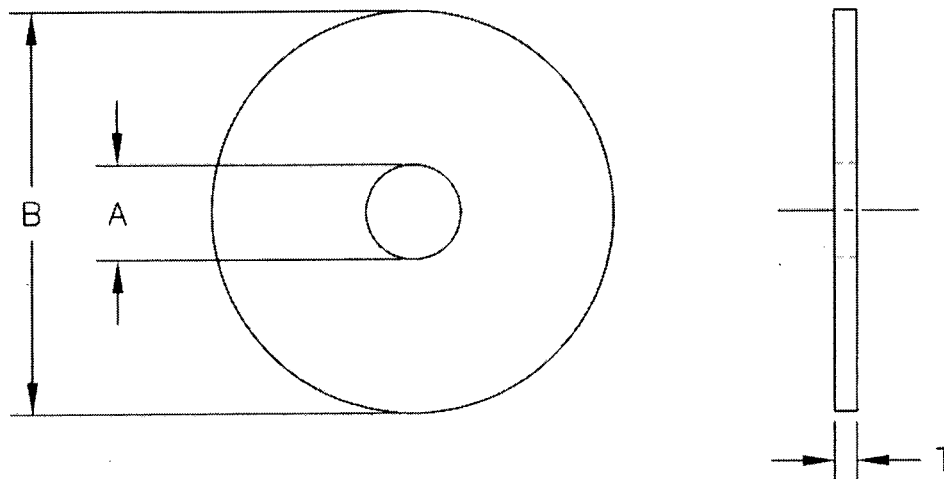
5.93

1.5' FK 13/11/05



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3411	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE WASHER, DELRIN	SCALE NTS
A	05.03.16	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



1) SPECIFICATION: **D3411-X WASHER**

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH NO.	BOLT SIZE	A (in)	B (in)	T (in) ±0.006	NON-METALLIC REPLACEMENT FOR:
-3	#10	0.203	0.875	0.063	AN970-3
-4	1/4	0.265	1.125	0.063	AN970-4
-5	5/16	0.328	1.375	0.063	AN970-5
-6	3/8	0.390	1.625	0.063	AN970-6
-7	7/16	0.453	1.812	0.109	AN970-7
-8	1/2	0.515	2.000	0.109	AN970-8

- 2) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

RELEASED
05.07.06 *[Signature]*

al 108699

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